

Date: Wednesday, 6/14/2006 1:45:08 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BUSHING
Job Number	: 27544	Part Number	: D26175
Estimate Number	: 10310	Drawing Number	: D2617 REV D2
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 6/14/2006	Drawing Revision	: D2
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 6/16/2006
Previous Run	: 24942	Qty:	30
Written By	: See comment below	Um:	Each
Checked & Approved By	: [Signature]		
Comment	: Est H 04.07.14 Reformat; added step 5 KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6T0500W058	6061-T6 Tube .500 x.058W	
		Comment: Qty.: 0.0205 f(s)/Unit Total : 0.6143 f(s) 6061-T6 Round Bar 1.5" Material: 6061-T6 (QQ-A-225/8 or QQ-A-200/8 or WW-T-700/6) Ø0.500" tubing x 0.058" wall M6061T6T0500W.058) Batch M19405	
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: HARDINGE CNC LATHE SMALL <i>N/A Machined Manually</i> 1-Machine as per Folio FA438 and Dwg D2617 2-Deburr	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/06/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

DC 06/06/15 (30)

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5153

FC 06/06/15 (30)

8.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

(30) 06/06/16

Job Completion



U 06-06-15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

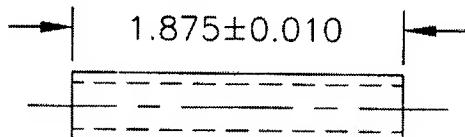
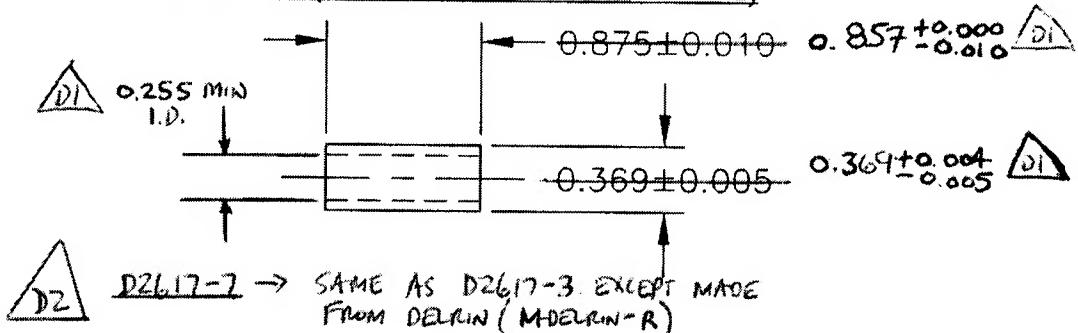
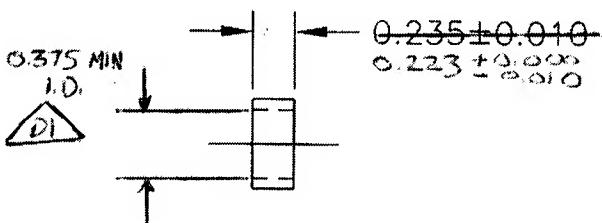
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

DART

DESIGN	BW	DRAWN BY	<i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>#</i>	APPROVED	<i>#</i>	DRAWING NO.	REV. D
				D2617	SHEET 1 OF 1
DATE				TITLE	SCALE
01.07.04				BUSHING	1:1
D2	04.04.10 <i>CP</i>	ADD D2617-7		A	96.10.08 NEW ISSUE
				B	97.05.08 .875 WAS 1.125
				C	97.06.04 0.369 DIA WAS 0.375
				D	01.07.04 ADD MAT'L SPEC AND TOL./DIM. NOTE
				DI	<i>CP</i> 04.07.12 CORRECT TOLERANCE (NCR 779)

D2617-1 (0.375 OD x 0.058 WALL)D2617-3 (0.375 OD x 0.058 WALL)D2617-5 (0.500 OD x 0.058 WALL)**RELEASED**
*01.07.05 CP*NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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DART AEROSPACE LTD	Work Order:	
Description: Bushing	Part Number:	D2617-5
Inspection Dwg: D2617 Rev: D2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:		Audited by:	J.G	Prototype Approval:	N/A
Date:	06/06/14	Date:	06/06/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.09	New Issue	KJ/JLM	
B	06.03.08	Dwg Rev change	KJ/JLM	